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71 Applicant: **Apsley Metals Limited**
Livery House 169 Edmund Street
Birmingham B3 2JB (GB)

72 Inventor: **Glover, Christopher J.**
23 Downer Close
Buckingham Bucks MK18 7DD (GB)

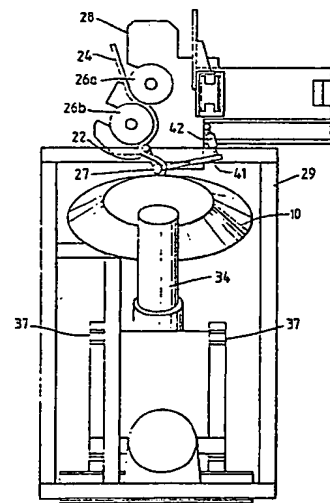
Goodfellow, Anthony Gerald
1 Avondale Avenue
Maghull Merseyside L31 7AA (GB)

74 Representative: **Weyland, Joseph Jean Pierre**
Goodyear Technical Center-Luxembourg Avenue Gordon
Smith
L-7750 Colmar-Berg (LU)

64 **Apparatus for the manufacture of a pneumatic tire.**

57 Apparatus and method for the manufacture of an annular uncured elastomeric component for a tire. The component (11) is formed on a disc-like mandrel (10) comprising a flexible support (12) having a frustoconical surface on which a strip of unvulcanised elastomeric material is wound to form the component, and a rigid carrier (13) on which the support (12) is mounted. The carrier (13) is adapted for mounting on a turning head (31) for rotation of the mandrel as the strip is laid onto said receiving surface. The flexible support (12) is used as a carrier to transfer the formed component to another tire building location.

Fig.4.



Description

Apparatus for the Manufacture of a Pneumatic Tire

This invention relates to a method and apparatus for the manufacture of a pneumatic tire and in particular to an apparatus and a method for forming an annular unvulcanised elastomeric component which can be assembled to a toroidal tire carcass.

The method and apparatus are particularly suitable for the manufacture and assembly of sidewall components to the mould carcasses of a radial tire.

In conventional radial tire manufacture the tire carcass is assembled on a flat drum and the sidewall components, apexes, and other components such as chaffers, bead reinforcements, etc., are added in the flat state. The carcass is then shaped up into a toroidal configuration prior to assembly of the breaker belt, tread, and sidewalls. The addition of the sidewalls in particular causes problems since they are typically produced from flat strip which is then wound around the toroidal carcass causing some distortions of the strip which may lead to sidewall blemishes in the finished tire.

Other proposed methods of sidewall assembly include producing an annular uncured sidewall in substantially its final shape in a discrete annular sidewall mould which is brought into contact with a shaped up carcass to fit the premoulded sidewall to the carcass. The sidewall mould then forms part of the tire curing mould. Such a method is proposed in British Patent GB2134439A. However this method has the disadvantage that it is not applicable to conventional tire building methods.

Accordingly there is provided an apparatus for the manufacture of an annular uncured elastomeric component for a tire and which comprises a flexible support having a surface thereon to receive a strip of unvulcanised elastomeric material, and a rigid carrier onto which the support is mounted, the carrier being adapted for mounting on a turning head for rotation of the mandrel as the strip is laid onto said receiving surface.

Preferably the apparatus further provides a means for producing unvulcanised elastomeric strip, a turning head for rotating the mandrel relative to the strip producing means so as to wind the strip onto the mandrel.

The unvulcanised strip may be produced by an extruder and the extrudate formed to its final shape by a calender before being wound onto the surface.

Conveniently the former has a frustoconical outer surface onto which the strip is wound and the mandrel is held at a orientation such that the frustoconical surface is substantially horizontal at the point of application of the strip to the mandrel.

Also according to this invention there is provided a method of manufacture of an uncured elastomeric annular component for a tire wherein the component is formed directly onto a flexible disc like mandrel by winding an unvulcanised elastomeric strip onto the mandrel, the mandrel with component in-situ is then transferred to a second location at which the component is assembled to a tire, preferably without being removed from the flexible Mandrel before

assembly to the tire has occurred.

The invention will be described by way of example and with reference to the accompanying drawings in which:

FIG 1 is a cross-section through a mandrel forming a part of the apparatus of the present invention

FIG 2 is a schematic drawing illustrating a method of manufacture of a tire component according to this invention.

FIG 3 is an elevation of an apparatus according to this invention showing the mandrel in-situ

FIG 4 is an elevation of the apparatus of FIG 3 showing the calender in-situ.

Now with reference to Fig 1 of the accompanying drawings, an annular component for a tire, preferably an uncured sidewall 11 for a radial carcass pneumatic tire, is produced on a mandrel 10 at one station and is then transferred in situ on the mandrel 10 to another station as a component in substantially its finished shape. The mandrel comprises an annular support 12, made preferably from a polyurethane elastomer, which is mounted on a rigid coaxial transferable carrier 13. The flexible support 12 in its relaxed configuration has a frustoconical outer surface 14 on which the sidewall 11, also in frustoconical form, is laid.

It will be seen that the radially inner surface of the carrier 13 has a conical seat 15 thereon and an annular latching groove 16 whose functions are associated with the mounting of the carrier to an apparatus for the forming of the sidewall 11 and also for the subsequent assembly of the sidewall to a tire at a second apparatus. There is also at least one air passage 17 extending through the flexible support 12 from the conical surface 14 to the radially outer cylindrical surface 18 of the carrier. This passageway may be utilised for the application of vacuum to hold the sidewall component in place, or for the application of air to separate the sidewall component from the polyurethane support 12. The flexible support 12 is utilised in a later process which does not form part of the present invention, for the transfer of the sidewall 11 to a toroidal tire carcass.

Now with reference to FIG 2, the uncured sidewall 11 is formed onto the mandrel 10 by spirally winding a strip 22 of uncured elastomeric material onto the frustoconical surface 14 of the mandrel.

The elastomeric sidewall material is processed by an extruder 23 and the extrudate 24 is fed to a conveyor 25 via a loop so as to even out variations in speed between the convey take-off and the extruder output. The extrudate while still warm is fed to a pair of calender rolls 26 which form part of a laying head 28 of the type described in European Application 87630236. The calendered strip 22 is then fed around an application roller 27, also on the head 28, to lay the strip onto the mandrel.

The mandrel 10 and on the laying head 2 are moved relative to each other, preferably by rotation

of the mandrel 10 about its axis whilst moving the laying head 28 radially of the mandrel to form then an uncured sidewall comprising a plurality of turns of strip on the mandrel in substantially its finished form.

The rotational speed of the mandrel is variable to compensate for the changing circumference of the mandrel surface as the strip is wound radially inwardly or outwardly so as to maintain a constant surface speed at the point of application of the strip to the mandrel.

With reference to FIG 3 and FIG 4 the extrudate strip 24 is passed between the rollers 26a and 26b of the laying head 28 which is mounted on a main frame 29 of the apparatus. The laying head is mounted on the frame 29 by means of struts (not shown) on which the head is moveable so that its position can be altered as is desired to lay the calendered strip across the frustoconical surface 14 of the mandrel 10. The laying head may be moved by screw threaded struts and the movement of the head is co-ordinated with the speed of the calender and the rotation of the mandrel so as to spirally wind an annular sidewall component 11 onto the surface of the mandrel, either in abutment or overlap as desired. The relationship between the mandrel rotation and the traversing speed of the laying head is also variable so that a desired amount of overlap between subsequent turns of the extrudate can be achieved. This enables a range of different profiles (cross sectional) to be made.

The mandrel 10 is mounted on a turning head 31 for rotation about its axis. The turning head 31 is located at the upper end of a cylindrical body 32 and is caused to rotate therein by a drive belt or chain 33 connected between a pulley 35, on a shaft connected with the head 31 and located at the lower end of the body 32, and a motor 34, preferably an electrical motor. The motor, 34, cylindrical body 32, and mandrel 10 are all mounted on a sub-frame 36 which in turn is mounted by pivots 37 to the main frame 29 so that the angle of orientation of the cylindrical body 32 and hence the mandrel can be altered relative to the frame 29 by operation of an actuator 38.

As illustrated in FIG 3 and 4 the mandrel 10 is orientated in the desired position for receiving the calendered strip 22, and is orientated with its axis at an angle to the vertical so that its frustoconical outer surface 14 is substantially horizontal at the point of application of the strip 22 to the mandrel. The calendered strip is fed onto the mandrel via an application roller 27 which may exert a light application load (500 gms) onto the strip as it is fed onto the surface of the mandrel.

The application roller 27 is mounted on an arm 41 pivoted to the laying head 28 which is moveable by an actuator 42 to lift the roller 27 off the mandrel or exert the application load.

The laying head 28 will move radially across the mandrel surface 14 as the strip is laid and on completion of the component the strip is cut by a cutter 43 (see FIG 2) which is mounted on the arm 41.

After completion of the forming of the sidewall 11, the mandrel 10 is reorientated so that its axis is vertical and the mandrel is removed from the turning

head 31 with the component in situ.

The mandrel and component are then taken to another machine station for assembly to a toroided tire carcass. This latter operation is described in our copending application filed on the same day as the present application.

Claims

1. Apparatus for the manufacture of an annular uncured elastomeric component (11) for a tire and which comprises a disc-like mandrel (10) on which an unvulcanised elastomeric component can be formed, characterised in that the mandrel (10) comprises a flexible support (12) having a surface (14) thereon to receive a strip (22) of unvulcanised elastomeric material, and a rigid carrier (13) onto which the support (12) is mounted, the carrier (13) being adapted for mounting on a turning head (31) for rotation of the mandrel (10) as the strip (22) is laid onto said receiving surface (14).

2. Apparatus is claimed in Claim 1, characterised in that the receiving surface (14) on the flexible support (12) is a frustoconical outer surface thereof (14).

3. Apparatus as claimed in Claim 2 characterised in that the carrier (13) supports only the radially inner portion of the flexible support (12) and the radially outer portion is displaceable relative to the carrier (13).

4. Apparatus according to any one of claims 1 to 3 characterised in that the apparatus further includes a turning head (31) on which the mandrel carrier (13) is detachably mounted and which is for rotating the mandrel (10) relative to a strip producing means (28) so as to wind the strip (22) onto the mandrel (10), the strip producing means (28) comprising an extruder (23) for forming an extrudate strip (24), and a laying head (28) including calender rolls 26 which receives the extrudate strip (24) and produces an accurately dimensioned strip (22) which is then laid onto the mandrel surface (14).

5. Apparatus as claimed in Claim 4 characterised in that the turning head (31) is pivotally mounted in an apparatus frame (29) so that the orientation of the axis of rotation of the mandrel (10) can be varied as desired, and the mandrel (10) is mounted on the turning head so that its frustoconical surface (14) is held substantially horizontal at the point of application of the strip (22) to said surface.

6. Apparatus as claimed in Claim 5 characterised in that the turning head (31) is rotatably mounted in a body (32) and is rotated by a drive means (34), the turning head body (32) and drive means (34) are mounted on a sub-frame (36) pivoted to the apparatus frame (29) so that orientation of the axis of rotation of the mandrel (10) is effected by movement of the sub-frame (36) relative to the main frame (29) so that said axis of rotation is substantially vertical for

mounting and dismounting of the mandrel onto the turning head (31), and is inclined at an angle to the vertical so that the frustoconical surface (14) is substantially horizontal for receiving the strip.

7. Apparatus as claimed in Claim 5 or Claim 6 characterised in that the laying head (28) is mounted on the apparatus frame (29) and is moveable radially of the mandrel (10) to spirally wind the strip (22) onto the mandrel to produce a component (11) from a plurality of turns of the strip, and the rotational speed of the mandrel (10) is variable so as to keep the surface speed of the mandrel at the point of application of the extrudate strip (22) substantially constant.

8. A method of manufacture of an uncured elastomeric annular component (11) for a tire in which the component is formed by winding an unvulcanised elastomeric strip (22) onto a mandrel (10) characterised in that the mandrel (10) is a flexible disc-like mandrel which is utilised as a carrier for transfer of said formed in-situ component from a strip producing means (28) to another location at which said component is assembled to a tire.

9. A method as claimed in Claim 8 characterised in that the elastomeric strip (22) is wound onto a frustoconical surface (14) of the mandrel (10) which rotates relative to a strip applicator (28), and the strip applicator (28) is radially moveable of the mandrel (10) to form a component onto said frustoconical surface, and the axis of rotation of the mandrel (10) is tilted from the vertical so that the frustoconical surface (14) is substantially horizontal at the point of application of the strip to the mandrel.

10. A method as claimed in Claim 9 characterised in that the orientation of the axis of rotation of the mandrel is variable such that the axis of rotation is held vertical for mounting and dismounting of the mandrel at a strip producing means (28) but is held tilted from the vertical during the winding operation.

11. A method as claimed in Claim 10 characterised in that the rotational speed of the mandrel (10) is varied so as to keep the surface speed of the mandrel substantially constant at a range of circumferences as the laying head (28) moves radially of the frustoconical surface (14).

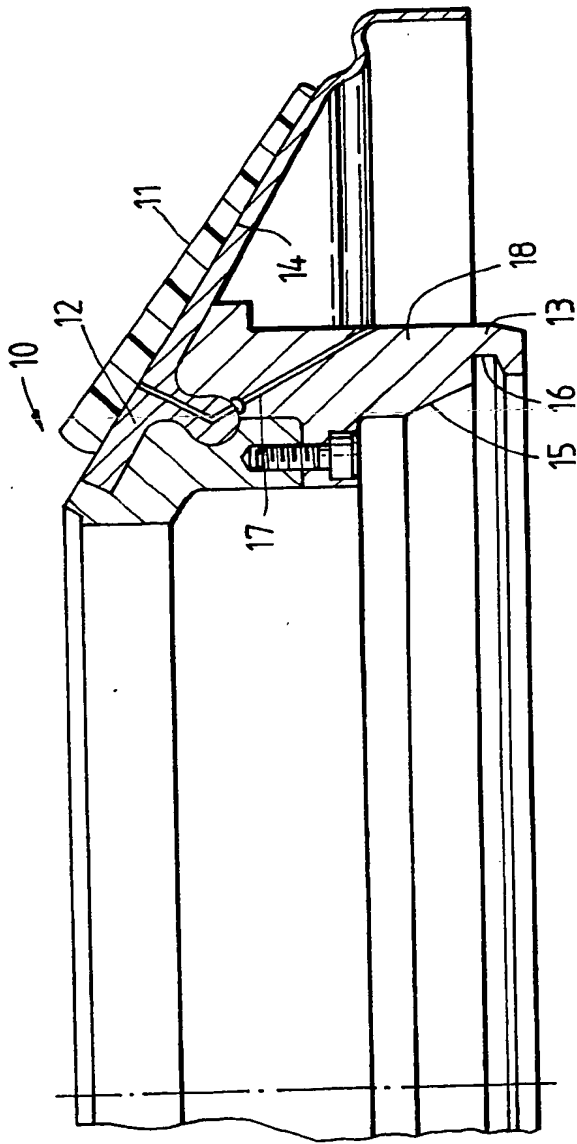


Fig.1.

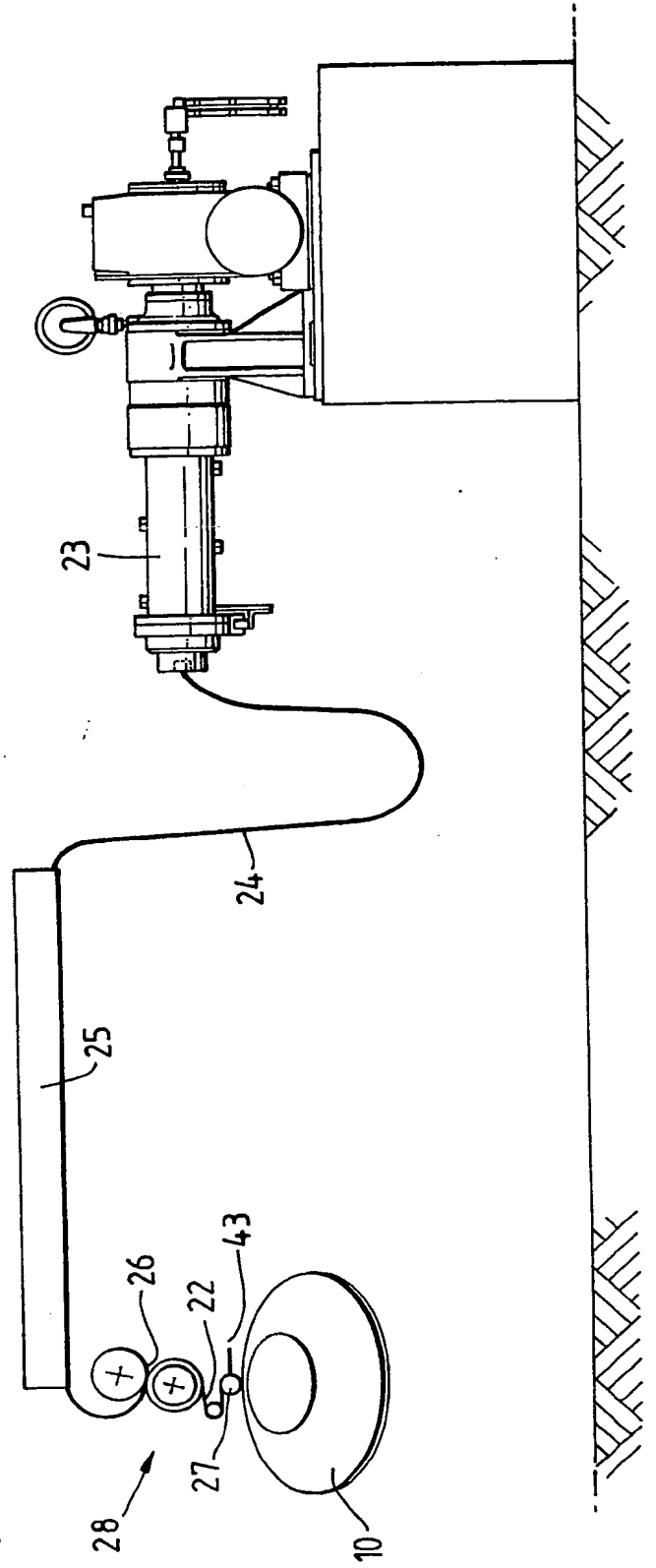


Fig.2.

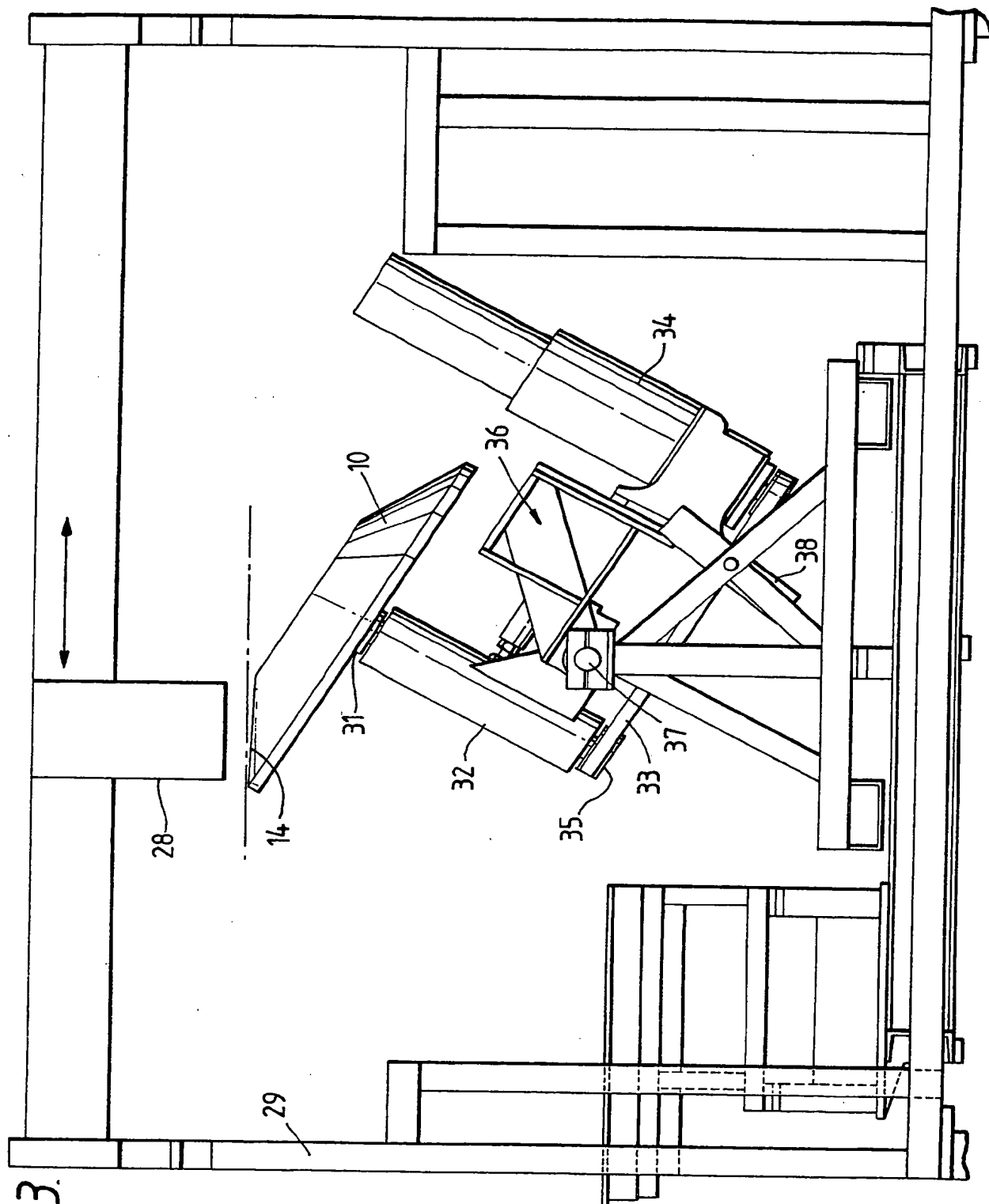
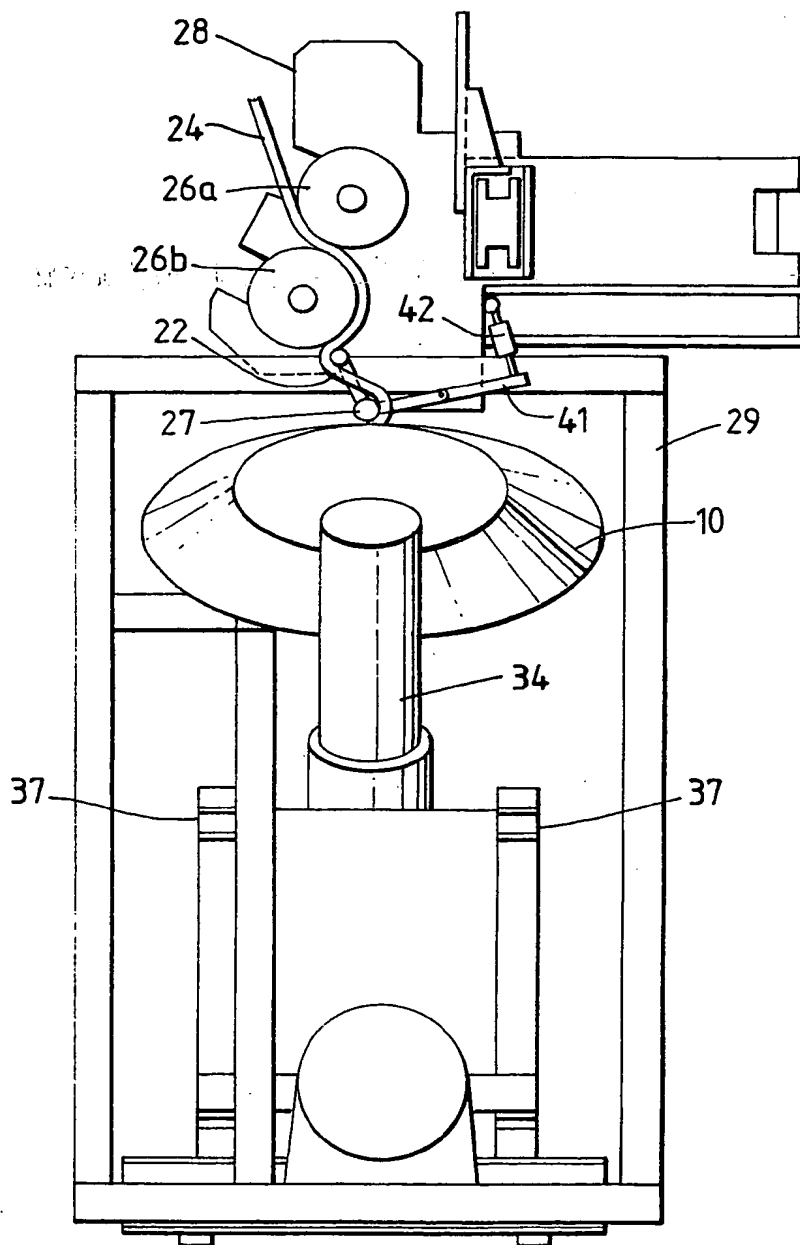


Fig.4.



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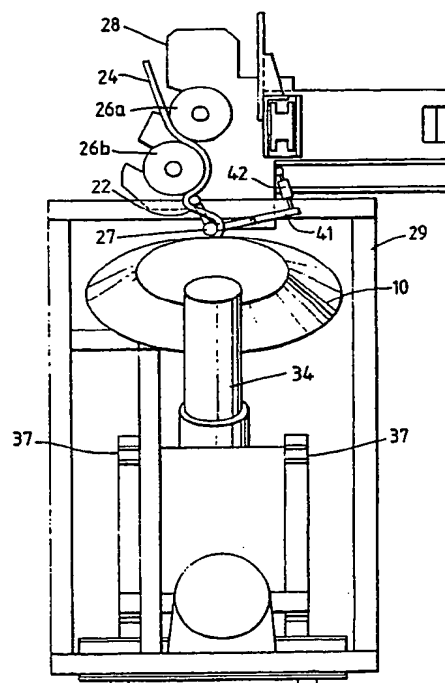
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16.10.91 Bulletin 91/42(71) Applicant: **Apsley Metals Limited**
Livery House 169 Edmund Street**Birmingham B3 2JB(GB)**

(72) Inventor: **Glover, Christopher J.**
23 Downer Close
Buckingham Bucks MK18 7DD(GB)
Inventor: **Goodfellow, Anthony Gerald**
1 Avondale Avenue
Maghull Merseyside L31 7AA(GB)

(74) Representative: **Weyland, Joseph Jean Pierre**
Goodyear Technical Center-Luxembourg
Avenue Gordon Smith
L-7750 Colmar-Berg(LU)

(54) **Apparatus for the manufacture of a pneumatic tire.**

(57) Apparatus and method for the manufacture of an annular uncured elastomeric component for a tire. The component (11) is formed on a disc-like mandrel (10) comprising a flexible support (12) having a frustoconical surface on which a strip of unvulcanised elastomeric material is wound to form the component, and a rigid carrier (13) on which the support (12) is mounted. The carrier (13) is adapted for mounting on a turning head (31) for rotation of the mandrel as the strip is laid onto said receiving surface. The flexible support (12) is used as a carrier to transfer the formed component to another tire building location.

Fig.4.**EP 0 340 147 A3**



European
Patent Office

EUROPEAN SEARCH REPORT

Application Number

EP 89 63 0077

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.5)
D,A	GB-A-2 134 439 (APSLEY METALS LIMITED) * the whole document * -----	1,8	B 29 D 30/72
D,P,A	EP-A-0 268 544 (APSLEY METALS LIMITED) * abstract; figures 1,2 * -----	4,9	
T	EP-A-0 313 506 (APSLEY METALS LIMITED) * the whole document * -----	1,8	
			TECHNICAL FIELDS SEARCHED (Int. Cl.5)
			B 29 C B 29 D
The present search report has been drawn up for all claims			
Place of search The Hague		Date of completion of search 21 August 91	Examiner SUENDERMANN R.O.
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